

Work Order ID 65557

January 19, 2011 1:43:42 PM



Page 1

Item ID:	D3651-5	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Top Flange					
Start Date:	1/20/11	Start Qty:	5.00	Cust Item ID:		
Required Date:	1/28/11	Req'd Qty:	5.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>mt</u>	Date:	<u>11-01-29</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3651	Rev B								

100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
304 .018	1-Cut as per Dwg D3651								
	Dwg-Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

HB 11-1-26

SB 11/01/27

(C)

(6)

HB 11-1-26

S.101/27

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3651-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Top Flange

Start Date: 1/20/11

Start Qty: 5.00



Cust Item ID:

Required Date: 1/28/11

Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Brake NC

Form as per dwg
NC BRAKE

Memo

0.00

0.00

SP 11/02/02

Brake NC

170



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Sulor103

x6

Quality Control

180



Packaging

Identify as per dwg & Stock Location:

GA

Memo

0.00

0.00

S 11/02/03

6

Packaging

B 65573

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D3651-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Top Flange

Start Date: 1/20/11 Start Qty: 5.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/04
MR
11-02-03

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Picklist Print

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Work Order ID: 65557



Parent Item: D3651-5

Parent Item Name: Top Flange



Start Date: 1/20/11

Required Date: 1/28/11

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP RevA 10.11.04 as per revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA  304/316 0.018 SHEET		Purchased	No			100	sf	109.6600	0.3	1.578947	21		
											11-1-24		

Location

Loc Qty

Loc Code

MAT20

109.66

109398

20.06

112885

89.6

112885

(6)

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DART AEROSPACE LTD		Work Order: 65557
Description: Top Flange		Part Number: D3651-5
Inspection Dwg: D3651	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.101	✓		RV62	
Ø0.129	+0.005/-0.001	.131	✓		✓	
0.26	+/-0.030	.262	✓		✓	
0.26	+/-0.030	.260	✓		✓	
2.21	+/-0.030	2.207	✓		✓	
1.66	+/-0.030	1.654	✓		✓	
3.16	+/-0.030	3.160	✓		✓	
0.36	+/-0.030	.358	✓		✓	
0.33	+/-0.030	.328	✓		✓	
0.500	+/-0.010	.498	✓		✓	
0.33	+/-0.030	.327	✓		✓	
0.500	+/-0.010	.498	✓		✓	
0.450	+/-0.010	.447	✓		✓	
0.19	+/-0.030	.191	✓		✓	
0.98	+/-0.030	.982	✓		✓	
0.48	+/-0.030	.480	✓		✓	
0.25	+/-0.030	.251	✓		✓	

Measured by: RB	Audited by: S	Prototype Approval: N/A
Date: 11-1-26	Date: 11/01/27	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.10.07	New Issue	KJ/DD	AS

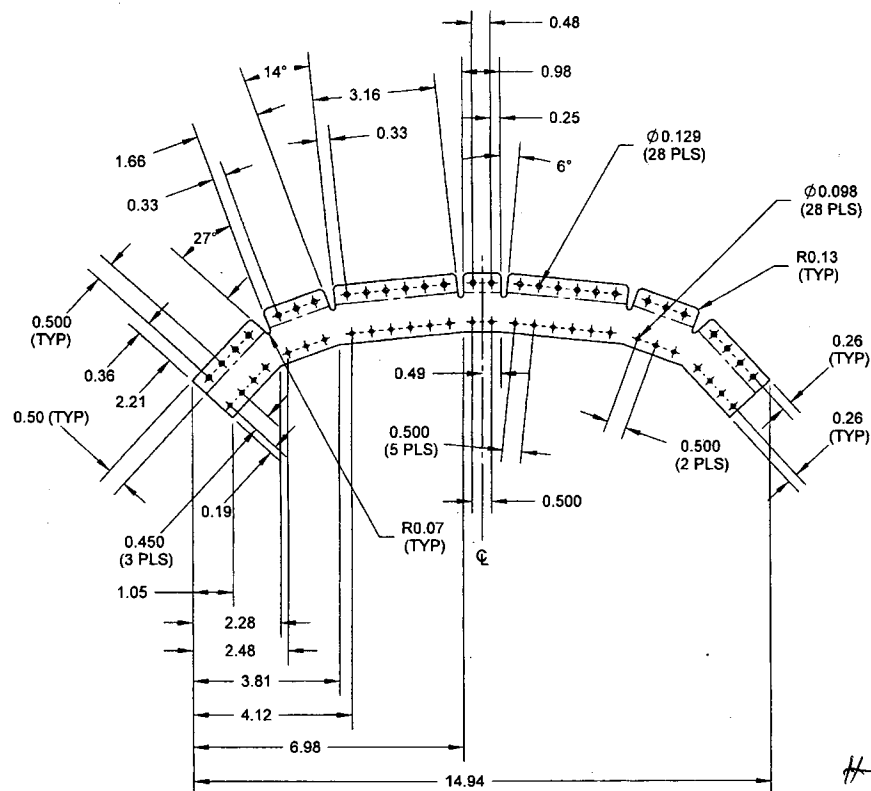
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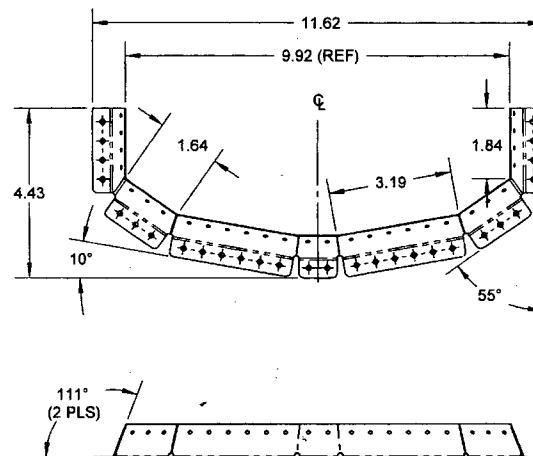
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D3651-5F FLAT PATTERN



D3651-5 TOP FLANGE BEND DETAIL
(MAKE FROM D3651-5F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3651	SHEET 5 OF 9
APPROVED		TITLE	SCALE
DE APPR.		AFT BASE ASSEMBLY	1:3
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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